

Work Order ID 53205

October 26, 2009 12:43:14 PM

Page 1

Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid.205/350

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *RP*Date: *09-10-26*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D2512	Rev E	

100 Weld per dwg A/R S.S. rod Batch: *M109213* 0.00
 Large Fab

Large Fab Memo 0.00

Large Fab 1-Cut 3/4" x 3/4" square tubing as per Dwg D2512
 2-Cut (4) D2236 From D3166-3
 3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305
 4-Weld as per Dwg D2512 using Welding Jig DT 9436
 Deburr as required
 INSTALL D2012-II7 CLEVIS ONLY ON D130-701-041

SM 09/10/29 *1x*

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC Memo 0.00

Quality Control

09 10 29

Work Order ID 53205

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

⇒ S or 10130



QC

Memo

0.00

Quality Control

130



Powdercoat

Powder Coating

PRESSURE-WASH

White Glass(Ref.4.3.5.1) per QSI005 4.3-Alum

M1112248

0.00

10 09/11/05

Memo

0.00

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME: 11:30AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 12:00PM

2ND COAT:

START TIME: 12:45PM

OVEN TEMPERATURE: 400°F

FINISH TIME: 1:15PM

11 09/11/05

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Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



HandFinishing

HandFinish

Memo M1124137 BLACK 0.00

Hand Finishing

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4
Batch: M1124137

BL 09-11-4

0.

150



QC3- Inspect Part Finish

0.00

MWD 09/11/05

QC

Memo

0.00

x1

Quality Control

160



Identify as per dwg & Stock Location: PMP

0.00

S3188 09/11/05

Packaging

Memo

0.00

Packaging

Work Order ID 53205

Page 4

October 26, 2009 12:43:15 PM

Item ID: D2512

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Setup Start



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Stop



Item Name: Basket Lid 205/350

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/05 HJ

PL 09-11-5

Picklist Print

October 26, 2009 12:43:20 PM

Page 1

4

Work Order ID: 53205**Parent Item:** D2512RevE**Parent Item Name:** Basket Lid 205/350**Start Date:** 26/10/2009**Required Date:** 04/11/2009**Comments:****Start Qty:** 1.00**Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2012-117RevC		Manufactured		No		100	Each	24.0000	2.0000			

Clevis

A

Warehouse**Location**

Main Warehouse

ST	24	
31101	2	
52498	22	

ONLY APPLICABLE ON D130-701-117

D2232-1RevC

Manufactured No

100 Each 26.0000 2.0000



Basket Hinge

*✓***Warehouse****Location**

Main Warehouse

ST	2	
48230	2	

Main Warehouse

WA	24	
50896	4	
51105	20	

*2x**SM 09/10/28*

Picklist Print

Page 2

October 26, 2009 12:43:21 PM

Work Order ID: 53205



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-1RevD		Manufactured	No			100	Each	41.0000	2.0000			

Spacer Bushing

✓

WarehouseLocation

Main Warehouse

ST

41

51331

16

52832

25

QX

8/09/10/28

D2506RevF

Manufactured

No

100

Each

13.0000 1.0000



Label Plate

✓

WarehouseLocation

Main Warehouse

ST

1

44275

1

Main Warehouse

WA

12

51303

2

52834

10

1X

8/09/10/28

Picklist Print

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Work Order ID: 53205



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			100	Each	66.0000	2.0000			

Mounting Bracket

✓

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST	13	
46086	2	
48428	1	
51120	10	

Main Warehouse

WA	53	
50872	4	
51745	49	

D3166-3RevA1

Manufactured No

100 Each 11.6210 1.0000

Basket Hoop

✓

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

WA	11.621	
50033	0.0527	
50618	0.5683	
51249	5	
52058	6	

Picklist Print

Page 4

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Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

✓ M304EX0.75-16F



Purchased

No

100

sf

476.5700

18.9474



Expanded Metal Flat SS

SAD 09-10-28

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	476.5700065
110134	3.4
111630	5.85
111956	0.000017
112147	8.29428947
112311	28.9205
112707	110.1052
112949	320

2.06

16,9474

✓ M304TS0.750W.065



Purchased

No

100

f

460.8319 45.8741



304 SQ Tube .75x.75x.065W

SAD 09-10-27

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA	460.8318947
112398	460.831895

45.8741

End Bar Scrap B#112398 Qty ~~1~~ 1.2 sq ft

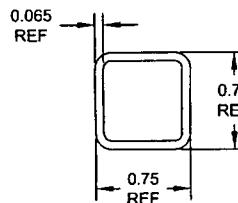
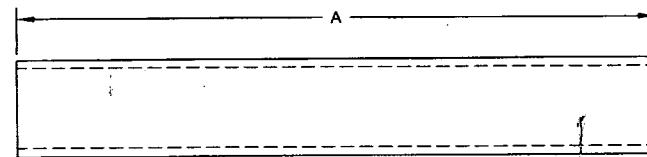
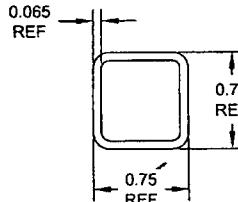
PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

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 NO. 53205

B10910-26



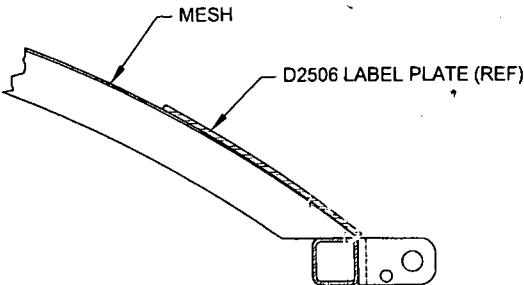
E

D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.75W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3. ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

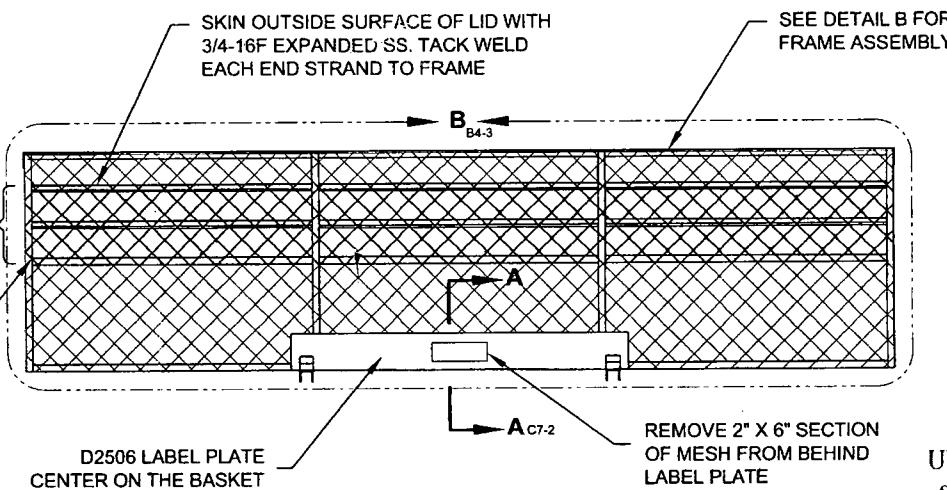
8 7 6 5 4 3 2 1



SECTION A-A_{B3-2}
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



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08.08.21/17



D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

DESIGN	BW	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. E
MFG. APPR.		D2512 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212) NTS
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6

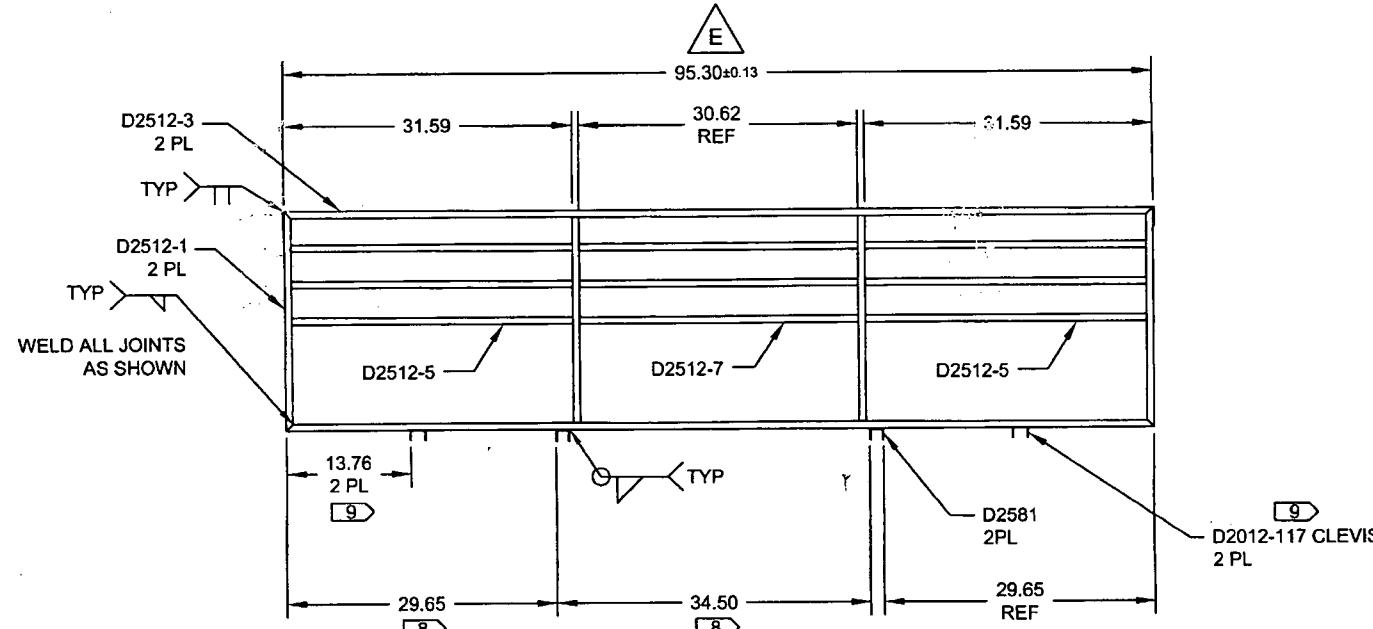
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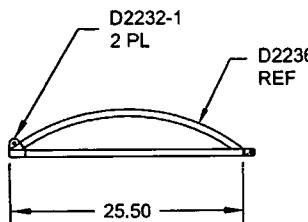
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1

1



DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR
CLARITY



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08-08-2011

OTES

MATERIAL: NONE

1 FINISH: NONE

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

· BREAK SHARP EDGES: N/A

IDENTIFICATION: NONE

WEIGHT: N/A

LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY.
PAGE D100, 724, 811, ONLY.

FOR B130-701-041 ONLY

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	<u> </u>	DRAWING NO.	REV. E	
MFG. APPR.	<u> </u>	D2512	SHEET 3 OF 4	
APPROVED	<u> </u>	TITLE	SCALE	
DE APPR.	<u> </u>	BASKET LID ASSEMBLY (350/212) NTS		
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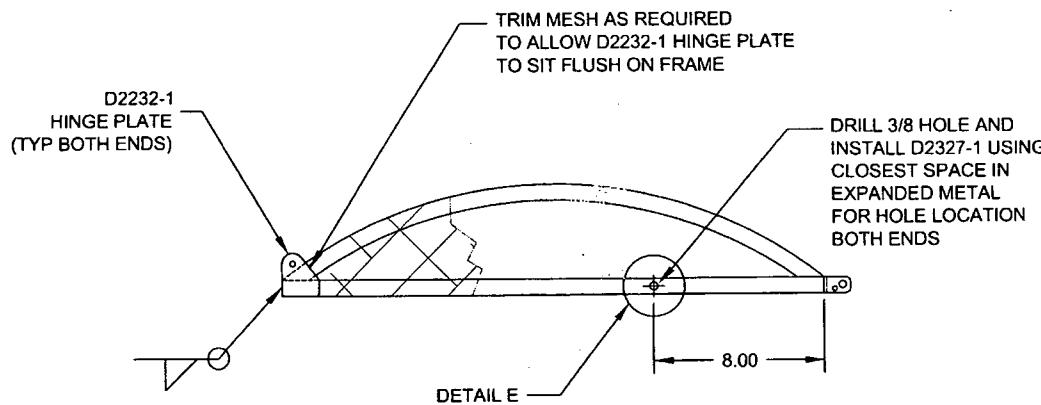
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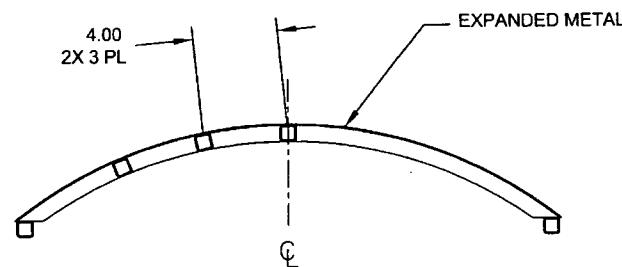
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1

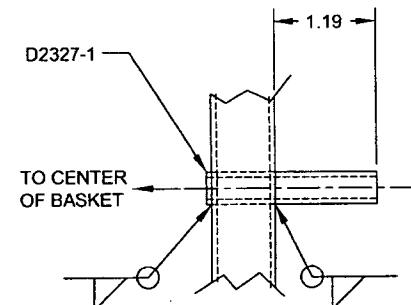


VIEW C-C SIMILAR BOTH END RIBS A5-2



SECTION D-D SAME BOTH CENTER RIBS A4-2

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08.06.17

DESIGN	BW	DART AEROSPACE LTD			
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA			
CHECKED	<i>AB</i>	DRAWING NO.			
MFG. APPR.	<i>AB</i>	D2512			
APPROVED	<i>AB</i>	REV. E			
DE APPR.	<i>AB</i>	SHEET 4 OF 4			
DATE	08.06.17	TITLE			
		BASKET LID ASSEMBLY (350/212)			
NTS					
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